

# Work Order ID 56806

March 10, 2010 1:30:05 PM



Page 1

Item ID: D350-589-041

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly LH

Stop



Start Date: 10/03/2010 Start Qty: 1.00

Required Date: 18/03/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-3-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2991	D
<del>DSI 9463</del>	<del>A</del>
IIN-D350-589	E

*N/A P10.04.29*

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP D350-589-041/~~DSI 9463~~  
CHG005

*5/10/05/06*

*HJ for CL 10/05/06*

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

*85 10-04-30*

*P10 ->*

# Dart Aerospace Ltd

W/O: 56806		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/20	# NO.1	Perm. change Trim AS requires to fit on mock helicopter - Prime + Paint as necessary AS Q57005	EC	10.05.03			S
			EC	10.05.07			10/04/20

Part No: D350-589-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56806**

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Page 2

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Required Date: 18/03/2010 Req'd Qty: 1.00




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Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00				85	10	05-04	
Small Fab	Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				④			
160  Packaging	Pick Kit	0.00							
Packaging	Memo	0.00				10-5-6	sl		

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/05/06

(80)

Quality Control

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-589-041/DSI 9463

Location:

PPP rev: FE

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

pho-7

10/05/06

10/05/07

mr  
10-5-6

# Dart Aerospace Ltd

W/O: 56866		WORK ORDER CHANGES						
DATE	STEP	Per. Date	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/6	#2 100		Part missing ADD to Kit D3895-1 B* <del>4689</del> qty x1 D3894-1 B* <u>4689</u> qty x1 B46897	SA	10-5-06			S 10/5/06
			ADD Parts to w/o + Bom per DSZ 7447 + 9446 ADD Log of new Bom as ref	BE	10-05-07			S 10/5/06

Part No: D350-589-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 56806

Parent Item: D350-589-041

Parent Item Name: Side Door Assembly LH

Comments: IPP rev. A 06.02.16 new issue, (was done on D350-589-041) EC  
 IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC  
 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

D2991-1	Manufactured	No	110	Each	0.0000	1.0000	
Side Door							
D2621	Manufactured	No	110	Each	55.0000	3.0000	
Latch Plate, 350 Spacepod							

B 56809

B 27 10-04-28

14

ET 10-04-30

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST021

55

46842

55

D2586

Manufactured No

110

Each

100.0000 3.0000



Door Latch

14

x3

ET 10-04-30

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

96

45554

1

50213

4

55314

91

Main Warehouse

ST204

4

56416

4

x3

W/O:		WORK ORDER CHANGES					
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 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-I-15

Purchased

No

110

Each

159.0000 3.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

159

112794

59

114056

100

D2464-1700

Manufactured

No

110

Each

0.0000 1.0000



Neoprene Seal

D3085-041

Manufactured

No

110

Each

6.0000 1.0000



prop ass'y

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

47186

2

47687

4

ST 10-04-30

ST

ST 10-05-04

ST 10-04-30

ST

March 10, 2010 1:30:11 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

D2585 Manufactured No 110 Each 73.0000 <sup>3</sup>/<sub>1</sub> 0000



Mounting Channel

EC 10-04-30

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST018 73

53798 13

55313 60

MS21042L3 Purchased No 110 Each 2,353.000 <sup>3</sup>/<sub>1</sub> 0000



Nut

x3

EC 10-04-30

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST300 2353

110844 35

111274 27

111668 58

112314 285

112385 228

113523 20

113537 700

113644 1000

AN960JD10 Purchased No 110 Each 0.0000 <sup>3</sup>/<sub>1</sub> 0000



Washer

NAS1149 003635

x3

EC 10-04-30

B114292 x3

March 10, 2010 1:30:11 PM

Shop Packet Print

Page 3

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 IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC  
 verified: DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

160

Each

1,717.000 6.0000



Rivet, Universal Head

10-5-68

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST319

1717

111916

1717

AN3-4A

Purchased

No

160

Each

1,920.000 6.0000



Bolt

10-5-68

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

1920

104214

393

104291

300

104322

200

104374

200

104625

300

104817

527

6

March 10, 2010 1:30:11 PM

Shop Packet Print

Page 4

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# D2991-1/-2/-3 SIDE DOOR

## NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 56806

2810-3-10

RELEASED  
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	CH		
DRAWN	CH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

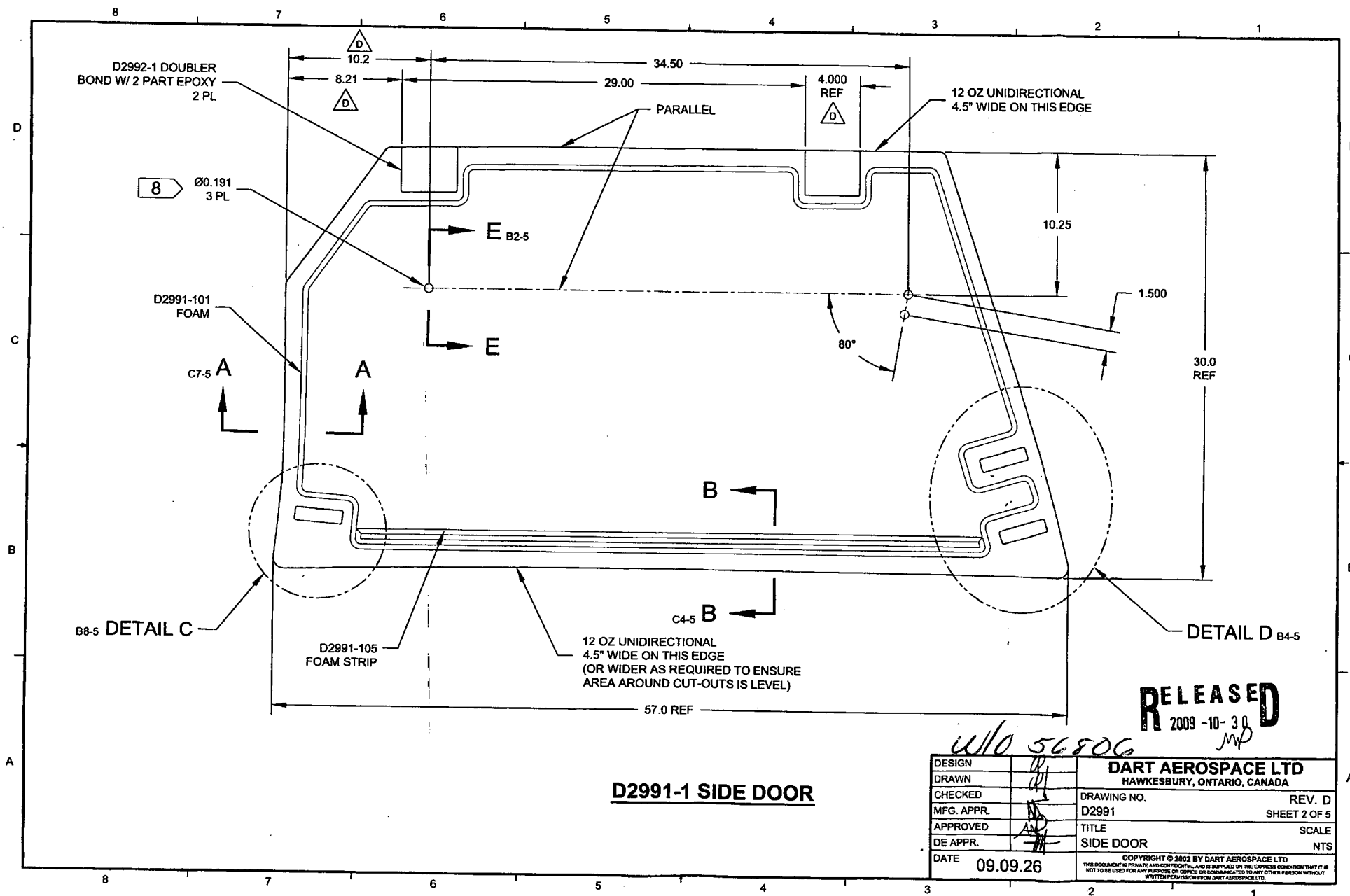
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DESIGN	W/0 56806	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2991	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		SIDE DOOR	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD	
DATE	09.09.26	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

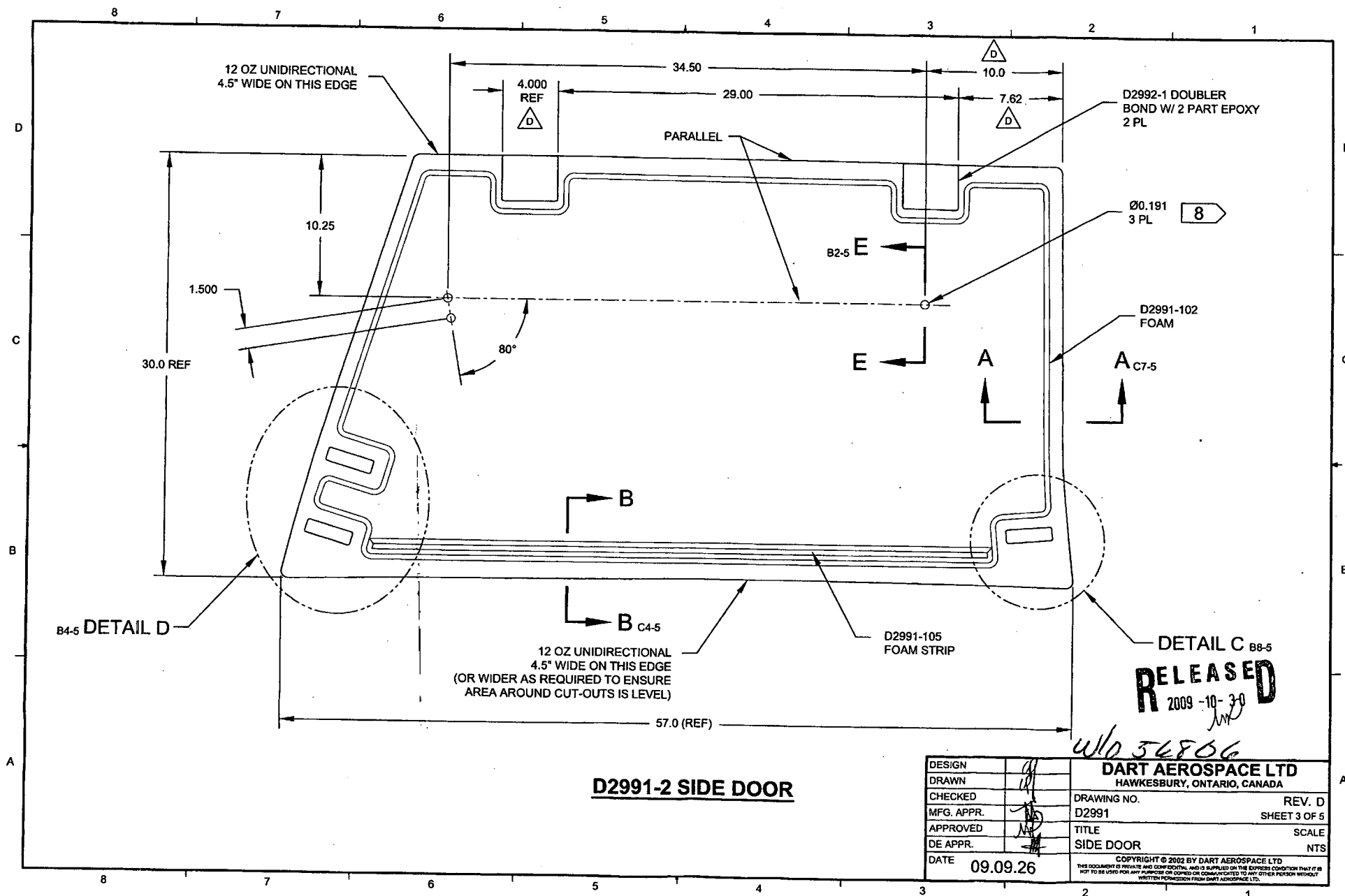
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# **D2991-2 SIDE DOOR**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2009-10-30

W10 54806

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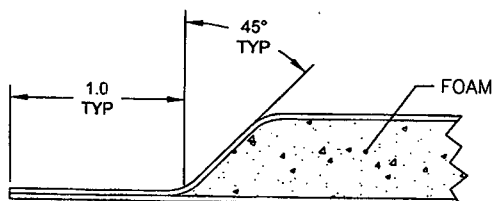
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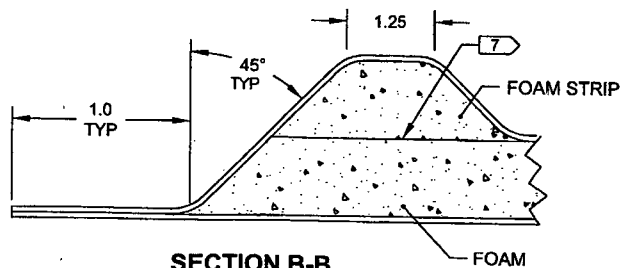
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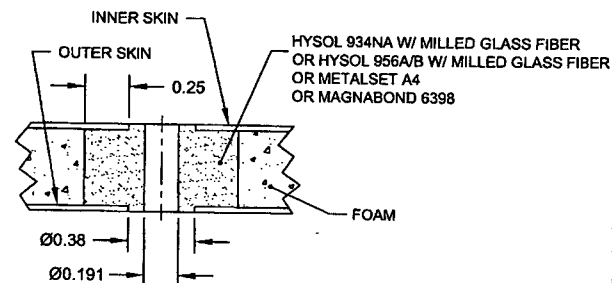




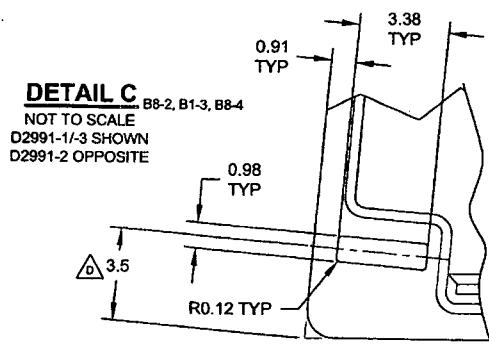
**SECTION A-A** C7-2, C2-3, C7-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



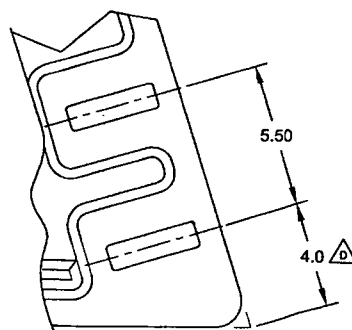
**SECTION B-B** B4-2, B5-3, B4-4  
ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



**SECTION E-E** D6-2, D3-3, C6-4  
TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE



**DETAIL C** B8-2, B1-3, B8-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



**DETAIL D** B1-2, B8-3, B1-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE

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MFG. APPR.		D2991	SHEET 5 OF 5
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E

AND

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1

REF CANADIAN STC: SH92-41

REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

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A	NEW ISSUE	CP	09.05.26
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MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 1 OF 5
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W/6-5680C






**To install the DSI-9463-011 Door Latch Kit:**

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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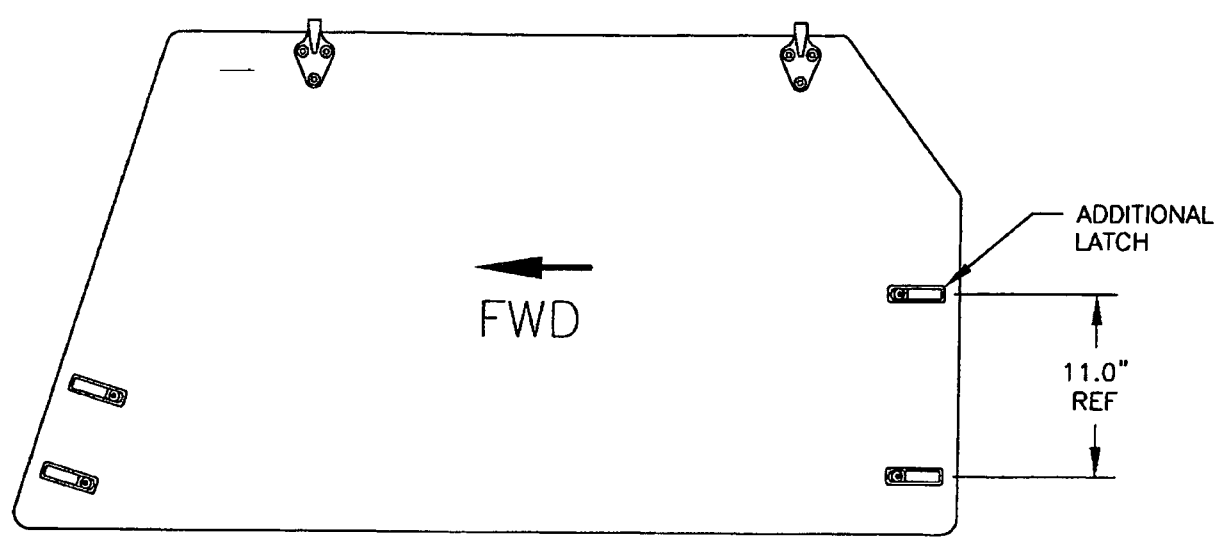
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WLO 56807



**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)**  
**D35X-589-042/-043 (SIMILAR)**

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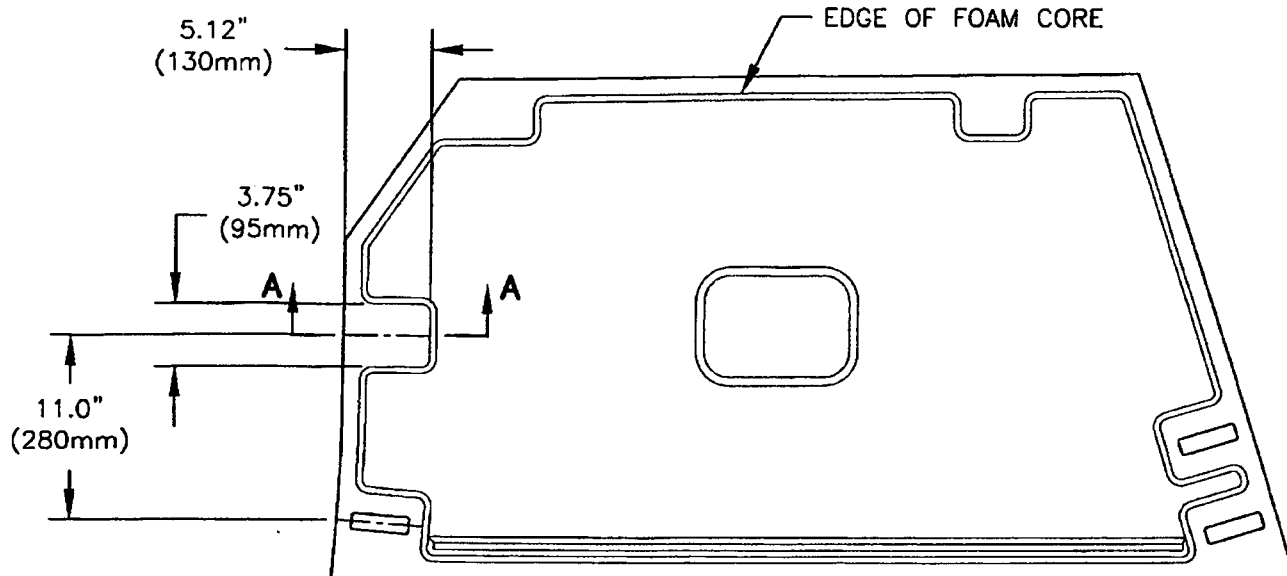
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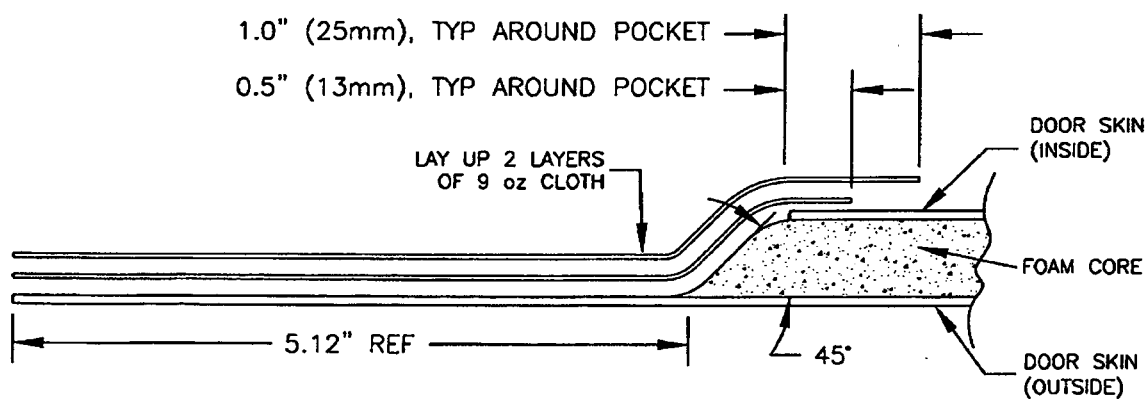
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**FIGURE 2: TRIMMING FOAM CORE  
(VIEW LOOKING AT INSIDE OF DOOR)  
(-041 SHOWN. -042/-043 SIMILAR)**









**SECTION A-A**

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DAO # 01-O-01

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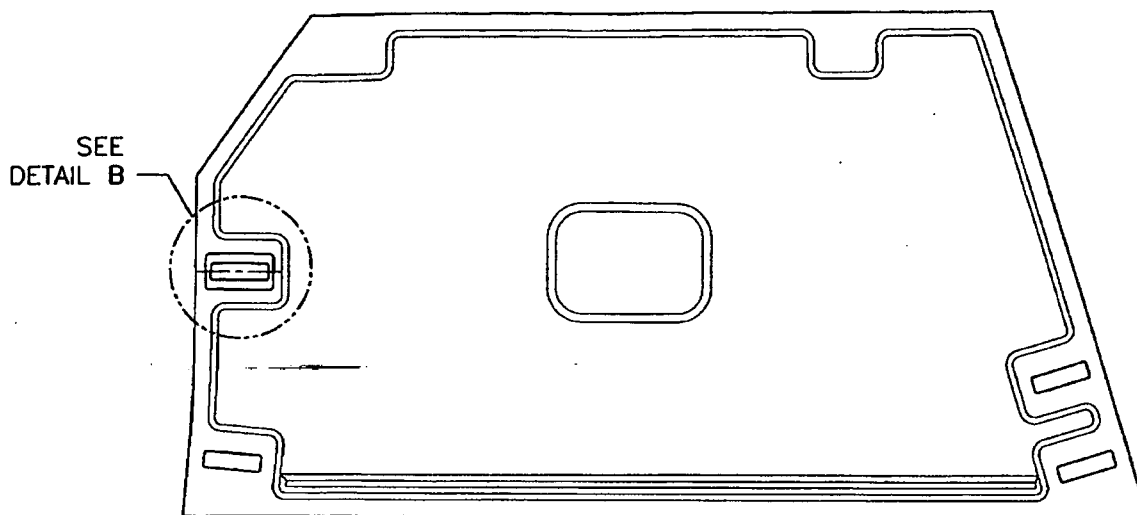
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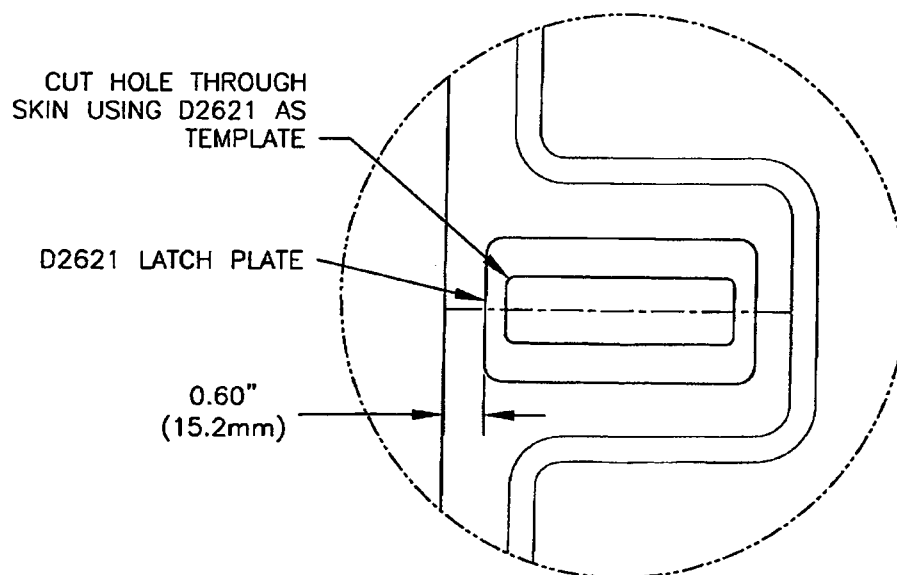
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W/O 56804



**FIGURE 3: CUTTING LATCH HOLE**



**DETAIL B**

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MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 5 OF 5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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REFERENCE ONLY

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2*	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

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**DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41

REF. FAA STC: SH1012NE

REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatibility with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x  $\varnothing$  0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes  $\varnothing$  0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

**PARTS LIST**

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.02.04  
CERT. NO.: SH92-41  
ISSUE NO.: 7

A	NEW ISSUE	<i>[Signature]</i>	09.02.04
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.	N/A	DSI 9447	SHEET 1 OF 3
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REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA D350-589 REV. 1 AND EARLIER

REF. TCCA STC SH92-41

REF. FAA STC SH1012NE

REF. AUSTRIAN STC ACG 21NE2093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x Ø0.129 (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

## PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAC # 01-C-01

APPROVED  
BY *[Signature]*  
D. SHEPHERD (DE # 02)  
DATE 09.02.03  
CERT. NO. SH92-41  
ISSUE NO. 7

A	NEW ISSUE	BY <i>[Signature]</i>	09.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MEG APPR.	N/A	DSI 9446	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SWITCH RELOCATION	NTS
DATE	09.02.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries